

**Work Order ID 58424**

May 6, 2010 2:42:56 PM



Page 1

Item ID: D2344

Accept



Setup Start



Revision ID:

Stop



Item Name: Litter Deck Plate, 350

Start Date: 06/05/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 13/05/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan: *PL*Date: *10-5-06*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D2344

Rev F

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

*2024 .063**F  
E**B10-6-1**5*

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

*B10-6-1*

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

*Solo661**45*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Deburr sharp edges ☐ 2-Countersink holes per Dwg D2344

*Handwritten signature*  
5/6/08/02 (5)

140

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

*Handwritten signature*  
8/6/06/02

(45)

150

0.00



Chemical Conversion Coat per QSI005 4.1

HandFinish

Memo

0.00

Hand Finishing

*Handwritten signature*  
10 06 03 (5)

W/O:		WORK ORDER CHANGES					
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**Work Order ID 58424**

May 6, 2010 2:42:56 PM



Page 4

Item ID: D2344

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Stop



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Start Date: 06/05/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 13/05/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/07 *[Signature]*  
MF  
10-6-7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

May 6, 2010 2:43:00 PM

Page 1

Work Order ID: 58424

Parent Item: D2344

Parent Item Name: Litter Deck Plate, 350


Comments: IPP Rev:D 00.06.26 Removed P/O for powder coat EC  
IPP Rev:E 07-07-04 Asper Rev F JLM

Start Date: 06/05/2010

Required Date: 13/05/2010

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			100	sf	172.5000	0.745	3.8		
												
2024-T3 .063 sheet												

Location	Loc Qty	Loc Code
MAT22	172.5	
111787	2	
113866	19.2	
113867	19.1	
114351	132.2	

114351

10-6-1

5

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	58424
<b>Description:</b> Litter Deck Plate Kit (350)		<b>Part Number:</b>	D2344
<b>Inspection Dwg:</b> D2344 <b>Rev:</b> F		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.223	+/-0.010	6.227	✓			
5.598	+/-0.010	5.599	✓			
4.869	+/-0.010	4.871	✓			
3.889	+/-0.010	3.889	✓			
3.096	+/-0.010	3.098	✓			
2.891	+/-0.010	2.894	✓			
16.973	+/-0.010	16.973	✓			
0.450	+/-0.010	.451	✓			
4.423	+/-0.010	4.425	✓			
4.723	+/-0.010	4.720	✓			
1.202	+/-0.010	1.200	✓			
5.869	+/-0.010	5.871	✓			
4.654	+/-0.010	4.650	✓			
Ø0.656	+0.005/-0.000	.656	✓			
1.888	+/-0.010	1.888	✓			
2.285	+/-0.010	2.288	✓			
2.683	+/-0.010	2.686	✓			
Ø0.171	+0.005/-0.000	.172	✓			
3.491	+/-0.010	3.490	✓			
Ø0.191	+0.005/-0.000	.193	✓			
3.123	+/-0.010	3.126	✓			
1.975	+/-0.010	1.975	✓			
Ø0.128	+0.005/-0.001	.132	✓			

<b>Measured by:</b> AB	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 10-6-1	<b>Date:</b> 10/06/01	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue      P/O D350-616-015	KJ/JLM	
B	07.07.17	Dwg Rev. updated	KJ/JLM	
C	07.09.06	Dimensions updated per Dwg. Rev. F	KJ/JLM	AB

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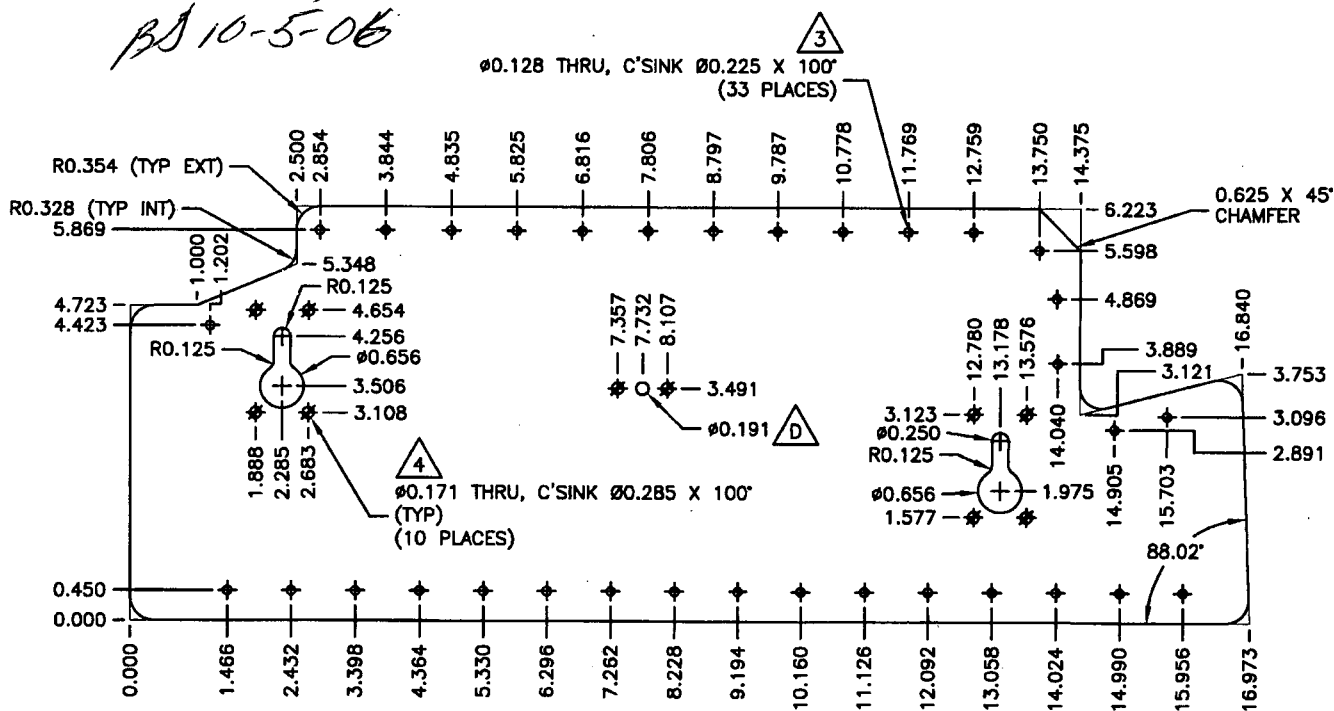
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**DART**

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 584124  
BS 10-5-06

DESIGN KE	DRAWN BY <i>PC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D2344	REV. F SHEET 1 OF 1
DATE 07.06.07		TITLE LITTER DECK PLATE, 350	SCALE 1:3
A	95.01.14	NEW ISSUE	
B	95.02.09	MOVED KEY HOLES	
D	95.03.06	0.191 WAS 0.197	
E	98.06.19	0.063-0.071 THICK WAS 0.071 (TSR A371)	
F	07.06.07	C'SINK Ø0.285 WAS Ø0.308	

**D2344 LITTER DECK PLATE, 350**

- E** 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063-0.071 THICK PER QQ-A-250/4  
(REF. DART SPEC. M2024T3S)
- F** 2) FINISH: POWDER COAT BLACK SANDTEX (REF. 4.3.5.7) PER DART QSI 005 4.3
- 3) COUNTERSINK HOLES MARKED  $\star$  TO Ø0.225 X 100"
- 4) COUNTERSINK HOLES MARKED  $\star$  TO Ø0.285 X 100"
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 8) IDENTIFY WITH DART P/N "D2344" USING WHITE PAINT MARKER

**RELEASED**07.06.22 *H*

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